

Date: Wednesday, 25/10/2006 2:40:31 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET ASSEMBLY
Job Number	29177	Part Number	D2803042
Estimate Number	11030	Drawing Number	D2803 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	25/10/2006	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	B
First Issue	N/A	Material	N/A
Previous Run	27283	Due Date	01/11/2006
Written By		Qty:	2
Checked & Approved By		Um:	Each
Comment	Est F 05.03.30 MS21043-3 was MS21042L3	KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28032	STA 84 Bracket
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) STA 84 BRACKET Pick: Qty Part Number Description Batch 1 D2803-2 Bracket <u>B 28 180</u>
2.0	D28052	Stop
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) STOP Pick: Qty Part Number Description Batch 1 D2805-2 Stop <u>B 29170</u>
3.0	D2809	Bushing
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing <u>B 28629</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/10/2006 2:40:31 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29177

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

MF 06/10/30 ②

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/30 ③

6.0 POWDER COATING POWDER COATING



M101575

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YL 06/10/30 X2

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION,

MF 06/10/30

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

MF 06/10/31 ②

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M101064

MF 06/10/31

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M101390

M100218

MF 06/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/01/31	12	Applied LPS. Hardcoat on washer and nut <u>M17045</u>	MF.	06/01/31	2	<i>AB</i> 06/01/31	<i>J</i> 06/01/31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29177

Part Number: D2803042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	NAS1515H3	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	<u>M100993</u>

A/R LPS-3 Corrosion Spray M101472

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

MF. 06/10/31

12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

MF. 06/10/31 (2)

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/31 (2)

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock ST157
Location: ST157

FINAL INSPECTION/W/O RELEASE

06/10/31 (2)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/10/31 (2)

Job Completion



06/10/31